



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4294-1

Job Sheet 167874



Part No: D4294-1

Job Qty: 8 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: PJ Helicopters Inc (CPJHI01)

903 Langley Way Red Bluff, CA, 96080 USA ph:(530) 527-5059 fx:(530) 527-1730.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	12/6/17	12/6/17	0.00	0.00	Start Up Machining		OK 17/12/20
100	Bandsaw	8 pcs	12/6/17	12/6/17	0.00	0.58	Bandsaw1		OK 17-12-20
110	CNC Vertical Machining	8 pcs	12/7/17	12/7/17	0.46	22.86	HAAS 5 Axis		OK 18-01-03
120	QC	8 pcs	12/7/17	12/7/17	0.00	0.00	QC2		OK 18-01-03
130	QC	8 pcs	12/7/17	12/7/17	0.00	0.00	QC8		OK 18-1-5
140	HandFinish	8 pcs	12/7/17	12/7/17	0.00	0.50	HandFinish1		2018/01/09 JSC
145	Powdercoat	8 pcs	12/7/17	12/7/17	0.00	0.56	Powdercoat1		BK 18-01-03
150	QC	8 pcs	12/7/17	12/7/17	0.00	0.00	QC3		OK 11
151	Small Fab	8 pcs	12/8/17	12/8/17	0.00	0.38	Small Fab		DAS 9-89
152	QC	8 pcs	12/8/17	12/8/17	0.00	0.00	QC5		38
180	Packaging	8 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3	ST533	AT 9-89 18-01-12
190	QC21-SA	8 Ea	12/8/17	12/8/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank to 7.125" ****GRAIN ALONG 4"*****

Descriptions: 110 - 1-Machine per folio FB008

145 - MASK THREADED HOLE

151 - INSTALL HELICOIL AS PER DWG

DAS
21
9-89

JAN 12 2018

M 138467. START: 9:05 O.T. 320° FINISH: 9:35.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T73B4.000x4.000	5	7	0	0
151-Small Fab	MS21209F1-10	8	27	0	0

FM137951-5

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.065Inches ± 0.010	0.075 0.055		
2	Fitting	0.063Inches ± 0.010	0.073 0.053	Radius	
3	Fitting	0.305Inches + 0.030 - 0.010	0.335 0.295		
4	Fitting	3.170Inches ± 0.030	3.200 3.140		

FM138253 X1 3025648
3017358 X7 3025692

DART
AEROSPACE
S025704

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Fitting

PART NO: D4294 - 1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/20/17

Job No: 167874

5	Fitting	3.110Inches ± 0.030	3.140 3.080
6	Fitting	0.325Inches ± 0.010	0.335 0.315
7	Fitting	0.780Inches ± 0.010	0.790 0.770
8	Fitting	0.800Inches ± 0.030	0.830 0.770
9	Fitting	1.560Inches ± 0.010	1.570 1.550
10	Fitting	0.500Inches ± 0.010	0.510 0.490
11	Fitting	0.070Inches ± 0.010	0.080 0.060
12	Fitting	0.390Inches ± 0.030	0.420 0.360
13	Fitting	0.500Inches ± 0.010	0.510 0.490
14	Fitting	0.880Inches ± 0.030	0.910 0.850
15	Fitting	3.440Inches ± 0.030	3.470 3.410
16	Fitting	2.450Inches ± 0.010	2.460 2.440
17	Fitting	2.040Inches ± 0.030	2.070 2.010
18	Fitting	1.528Inches ± 0.010	1.538 1.518
19	Fitting	0.300Inches ± 0.010	0.310 0.290
20	Fitting	0.738Inches ± 0.010	0.748 0.728
21	Fitting	0.250Inches ± 0.030	0.280 0.220
22	Fitting	3.375Inches ± 0.010	3.385 3.365
23	Fitting	4.8750Inches ± 0.0100	4.8850 4.8650
24	Fitting	1.670Inches ± 0.010	1.680 1.660
25	Fitting	0.386Inches + 0.006 - 0.001	0.392 0.385
26	Fitting	0.266Inches + 0.006 - 0.001	0.272 0.265
27	Fitting	6.810Inches ± 0.030	6.840 6.780
28	Fitting	6.350Inches ± 0.030	6.380 6.320
29	Fitting	1.460Inches ± 0.030	1.490 1.430
30	Fitting	0.050Inches ± 0.010	0.060 0.040
31	Fitting	3.440Inches ± 0.010	3.450 3.430
32	Fitting	4.968Inches ± 0.010	4.978 4.958
33	Fitting	0.875Inches + 0.010 - 0.001	0.885 0.874
34	Fitting	0.332Inches + 0.020 - 0.010	0.352 0.322
35	Fitting	0.750Inches ± 0.010	0.760 0.740
36	Fitting	6.490Inches ± 0.030	6.520 6.460
37	Fitting	0.691Inches ± 0.010	0.701 0.681

38	Fitting	0.640Inches $\pm$ 0.030	0.670 0.610
39	Fitting	0.201Inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.206 0.200
40	Fitting	0.320Inches $\pm$ 0.010	0.330 0.310
41	Fitting	100Degrees $\pm$ 0	100 100
42	Fitting	0.764Inches $\pm$ 0.010	0.774 0.754
43	Fitting	0.381Inches $\begin{matrix} + 0.000 \\ - 0.001 \end{matrix}$	0.381 0.380
44	Fitting	1.405Inches $\pm$ 0.010	1.415 1.395
45	Fitting	1.125Inches $\pm$ 0.010	1.135 1.115

Plex 11/7/17 2:18 PM dart.poulin.mario

DART AEROSPACE LTD		Work Order:	167874
Description: Fitting		Part Number:	D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	+/-0.010	.065	✓		SLIO	
R0.063	+/-0.010	.0625	✓		Rael gauge	
0.305	+0.030/-0.010	.305	✓		SLIO	vern
3.17	+/-0.030	3.170	✓			
3.11	+/-0.030	3.110	✓			
0.325	+/-0.010	.325	✓			
0.780	+/-0.010	.780	✓			
0.80	+/-0.030	.800	✓			
1.560	+/-0.010	1.560	✓			
0.500	+/-0.010	.500	✓			
0.070	+/-0.010	.070	✓			
0.39	+/-0.030	.390	✓			
0.500	+/-0.010	.500	✓			
0.88	+/-0.030	.880	✓			
3.44	+/-0.030	3.440	✓			
2.450	+/-0.010	2.450	✓			
2.04	+/-0.030	2.040	✓			
1.528	+/-0.010	1.528	✓			
0.300	+/-0.010	.300	✓			
0.738	+/-0.010	.738	✓			
0.25	+/-0.030	.250	✓			
3.375	+/-0.010	3.375	✓			
4.875	+/-0.010	4.875	✓			
1.670	+/-0.010	1.670	✓			
Ø0.386	+0.006/-0.001	.386	✓			
Ø0.266	+0.006/-0.001	.267	✓			
6.81	+/-0.030	6.810	✓			
6.35	+/-0.030	6.350	✓			
1.46	+/-0.03	1.460	✓			
0.050	+/-0.010	.050	✓			
3.440	+/-0.010	3.440	✓			
4.968	+/-0.010	4.968	✓			
Ø0.875	+0.010/-0.001	.875	✓			
0.332	+0.020/-0.010	.332	✓			
Ø0.750	+/-0.010	.750	✓			
6.49	+/-0.030	6.490	✓			
0.691	+/-0.010	.691	✓			

